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D3140-101
Job Sheet 192626



Part No: D3140-101

Job Qty: 8 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/28/19

Job Tracking No: Order 13294

Due Date: 4/26/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV F IPP A 02.04.30 New Issue NG IPP B IPP rev.C added scuffing NCR 061 EC IPP Rev:D As per ECN #829 06-11-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Waterjet - Flow - 1	8 pcs		4/26/19	0.00	0.28	Waterjet - Flow		DL 19/06/13
120	QC 8	8 pcs		4/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - 2 - B4B	8 pcs		4/26/19	0.00	0.21	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
140	Handfinish - 1-1 Chemical-B4B	8 pcs		4/26/19	0.00	0.48	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		

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					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	8 pcs	4/26/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
160 Packaging 3-1 - Stock - B4B	8 pcs	4/26/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 6A-TDD
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	DAS
170 QC 21 - SA	8 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21	DAS 6A-TDD
				QC 21 - SA - 70	21 2-85
				QC 21 - SA - 53	2-85

Part Op 100 - 1-Cut as per Dwg D3140 Dwg Rev: _____ Prog Rev: _____ 2-Debur if necessary

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - 1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Debur. No sharp edges

140 - (Chemical Conversion Coat per QSI005 4.1)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

JUN 19 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	.3552 sf (.0444 ea)	100-Waterjet - Flow - 1	50135848

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	0	217	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	2.200inches ± 0.030	2.230 2.170		
2	Doubler	2.800inches ± 0.030	2.830 2.770		
3	Doubler	2.050inches ± 0.030	2.080 2.020		
4	Doubler	0.032inches ± 0.010	0.042 0.022		

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Container No: S190040



Part: D3140-101

Job No: 192626

Serial No/Batch: S190040

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 06/13/19

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